

Work Order ID 57140

Tuesday, March 23, 2010 3:40:48 PM



Page 1

Item ID: D4030-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly, Light Lid (350)

Start Date: 3/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/2/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mp*

Date: *10-3-23* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	A								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

10/4/05

10/04/06

8 10/04/06

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 4/2/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

NVA

0.00

Packaging

C19/4/6

①

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06

MF 10-4-6

W/O:		WORK ORDER CHANGES					
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Work Order ID: 57140

Parent Item: D4030-043

Parent Item Name: Long Basket Assembly, Light Lid (350)



Start Date: 3/25/2010

Required Date: 4/2/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN310C4 		Purchased	No				Each	0.0000	3.0000			
Nut AN3-20A 		Purchased	No				Each	61.0000	2.0000			
Bolt												

M 114306
15932
16463
6/4/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST352

61

105125

50

15432

11

R AN5-10A 21A


Purchased No

Bolt
D2530


Manufactured No

Handle Weldment

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST506

2

55612

2

Main Warehouse

ST508

12

56058

12

56058

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2535



Spring

Manufactured

No

Each

49.0000

2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST504

49

56355

49

56355

D2537



Bushing

Manufactured

No

Each

45.0000

4.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST504

45

53181

45

53181

D3917-3



Washer

Manufactured

No

Each

0.0000

6.0000



57144

D3953-3



Gas Spring Stud, Lid

Manufactured

No

Each

15.0000

2.0000



53757

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST101

15

53757

15

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Shop Packet Print

Page 2

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Required Date: 4/2/2010


Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3953-7  Spring Spacer		Manufactured	No				Each	32.0000	2.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST101	32	
52758	2	
53970	30	

D3953-9  Gas Spring Washer		Manufactured	No				Each	58.0000	2.0000 			
-------------------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	--	------	---------	-----------------------------------------------------------------------------------------------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST101	58	
53642	58	

D3953-17  Gas Spring Spacer		Manufactured	No				Each	3.0000	2.0000 			
----------------------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	--	------	--------	-------------------------------------------------------------------------------------------------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST101	3	
52763	3	

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Parent Item Name: Long Basket Assembly, Light Lid (350)


Start Date: 3/25/2010

Required Date: 4/2/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3953-19  Gas Spring Bracket		Manufactured	No				Each	8.0000	1.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ENG

56324

8

8

Each

7.0000

1.0000

56324

57145

D3953-21



Gas Spring Bracket

Manufactured

No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ENG

56407

7

7

Each

10.0000

1.0000

D3969-3



Spring (Basket Lid)

Manufactured

No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ENG

55716

10

10

Each

0.0000

1.0000

D3915-041



Light Lid Assembly, Long Basket Assembly

Manufactured

No

B57075



55716 PREM

EP10/04/06

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Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Long Basket Assembly, Light Lid (350)





Start Date: 3/25/2010

Required Date: 4/2/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3913-041 <i>AS</i>		Manufactured	No				Each	0.0000	1.0000			
												
Long Basket Lid Assembly (350)												
AN3-14A		Purchased	No				Each	54.0000	4.0000			
												
Bolt												

B57070

8/5/10/04/06

EC

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST351	54	
105953	15	
109754	39	

AN310-4		Purchased	No				Each	44.0000	3.0000			
												
NUT												

109859

EC 10/4/10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST314	44	
112969	9	
113845	35	

1113845

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Long Basket Assembly, Light Lid (350)



Start Date: 3/25/2010

Required Date: 4/2/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-12  Bolt		Purchased	No				Each	22.0000	3.0000 			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST357

22

104016

22

AN5-17A

Purchased

No



Bolt

Each

43.0000

4.0000


1710444

10144/5

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST339

43

102140

4

113538

39

17113038

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 3/25/2010

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Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No				Each	2,092.000	6.0000			
Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

2092

110844

35

111274

27

111668

58

112314

285

113523

20

113537

667

113644

1000

M113537

MS21042L5

Purchased

No



Nut

Each

500.0000

4.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

500

110382

10

111636

1

112314

17

113523

76

113537

196

114108

200

M113537

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 3/25/2010

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Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS24665-151

Purchased

No

Each

816.0000

3.0000



Cotter Pin

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST309

816

14526

3

17566

813

MS24665-300

Purchased

No

Each

106.0000

2.0000



Cotter Pin

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST309

106

105279

6

110123

100

NAS1149C0432R

Purchased

No

Each

0.0000

2.0000



Washer

17566

105279

110492

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149F0332P WASHER		Purchased	No				Each	1,110.000	8.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST275

1110

18057

1110

NAS1149F0432P Washer		Purchased	No				Each	403.0000	6.0000			
-----------------------------	--	-----------	----	--	--	--	------	----------	--------	--	--	--

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST275

403

110098

200

112940

100

18057

103

NAS1149F0563P Washer		Purchased	No				Each	104.0000	4.0000			
-----------------------------	--	-----------	----	--	--	--	------	----------	--------	--	--	--

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST275

104

108099

8

108471

96

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Shop Packet Print

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

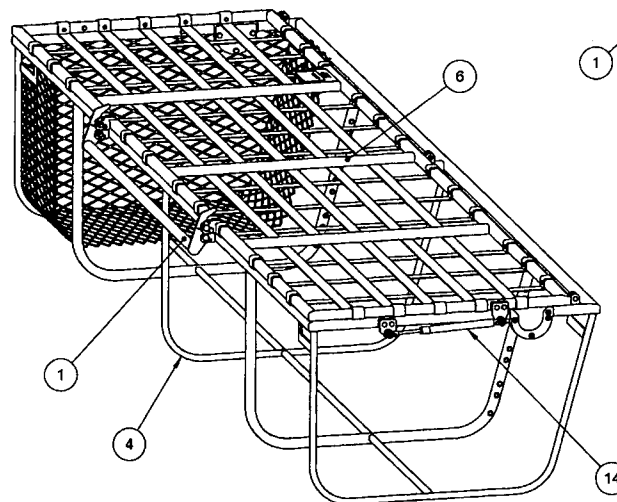
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

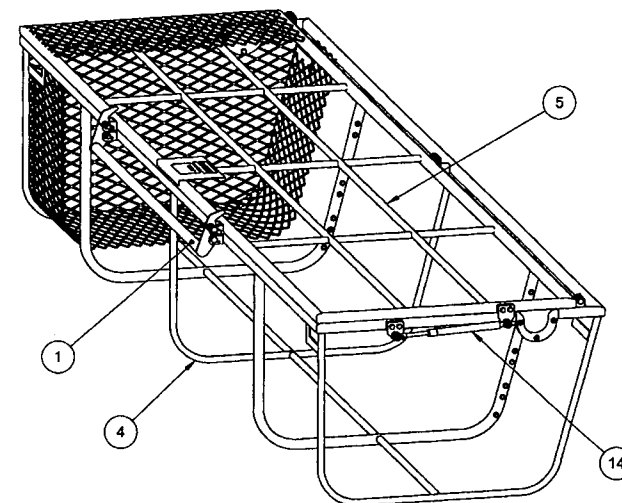
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-18A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	8	8	NAS1149F0332P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	6	6	NAS1149F0432P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: -041: 72 lbs APPROX
 -043: 57 lbs APPROX

#57140

RELEASED
 2010-03-22
 MP

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D4030		SHEET 1 OF 3	
TITLE LONG BASKET ASSY (350)		SCALE NTS	
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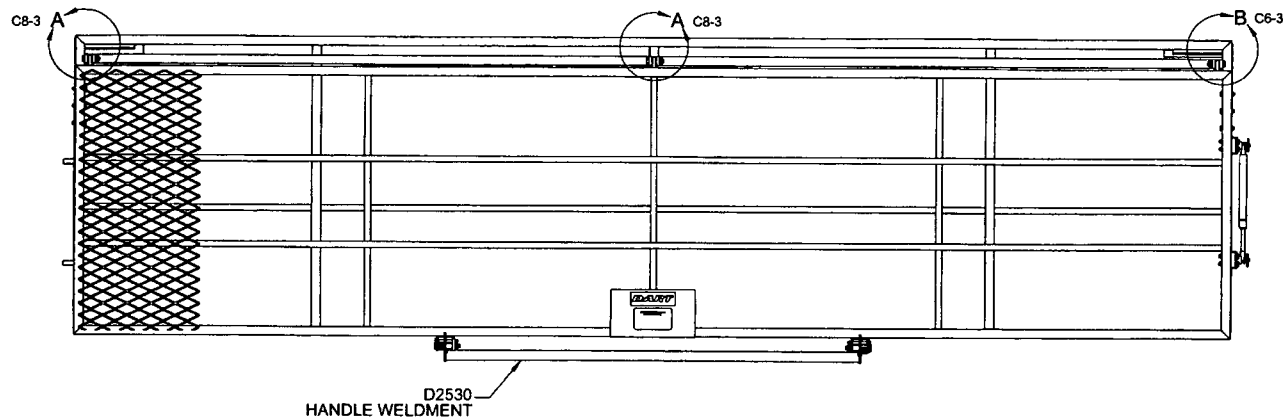
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

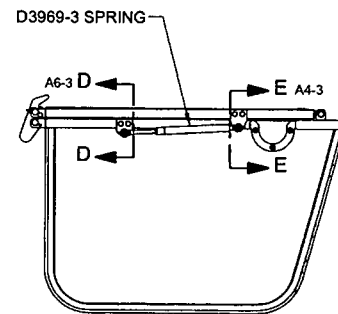
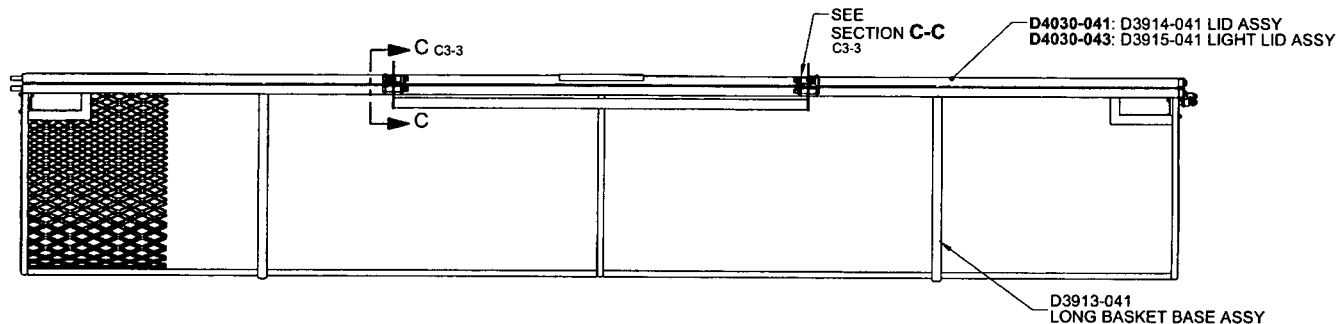
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1







#57140



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-22
JMD

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

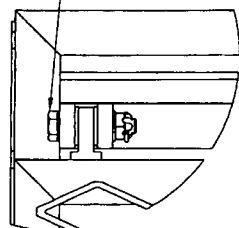
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

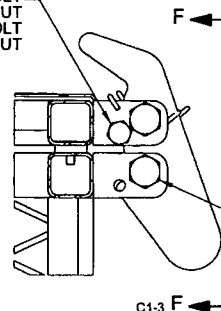
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



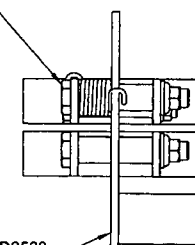
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-19A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL





D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

#57140

RELEASED
2010-03-22
JMD

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NT
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries